

**Gas welding equipment - Acetylene manifold systems
for welding, cutting and allied processes - Safety
requirements in high-pressure devices (ISO 15615:2013)**

EESTI STANDARDI EESSÕNA

NATIONAL FOREWORD

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English Version

**Gas welding equipment - Acetylene manifold systems for
welding, cutting and allied processes - Safety requirements in
high-pressure devices (ISO 15615:2013)**

Matériel de soudage aux gaz - Centrales de détente pour la
distribution d'acétylène pour le soudage, le coupage et les
techniques connexes - Exigences de sécurité pour les
dispositifs haute pression (ISO 15615:2013)

Gasschweißgeräte - Acetylenflaschen-Batterieanlagen für
Schweißen, Schneiden und verwandte Prozesse -
Sicherheitsanforderungen für Hochdruckeinrichtungen (ISO
15615:2013)

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Management Centre: Avenue Marnix 17, B-1000 Brussels

Foreword

This document (EN ISO 15615:2013) has been prepared by Technical Committee ISO/TC 44 "Welding and allied processes" in collaboration with Technical Committee CEN/TC 121 "Welding" the secretariat of which is held by DIN.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by October 2013, and conflicting national standards shall be withdrawn at the latest by October 2013.

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Endorsement notice

The text of ISO 15615:2013 has been approved by CEN as EN ISO 15615:2013 without any modification.

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Gas welding equipment — Acetylene manifold systems for welding, cutting and allied processes — Safety requirements in high-pressure devices

1 Scope

This International Standard establishes the general specifications, requirements and tests for devices located on the high-pressure side of acetylene manifold systems as defined in ISO 14114. It does not cover the high-pressure piping, flexible hoses and the regulator.

NOTE The terms “upstream” and “downstream” refer to the normal direction of gas flow in the device.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 2503:2009, *Gas welding equipment — Pressure regulators and pressure regulators with flow-metering devices for gas cylinders used in welding, cutting and allied processes up to 300 bar (30 MPa)*

ISO 9090, *Gas tightness of equipment for gas welding and allied processes*

ISO 9539, *Gas welding equipment — Materials for equipment used in gas welding, cutting and allied processes*

ISO 10297, *Gas cylinders — Cylinder valves — Specification and type testing*

3 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

3.1

non-return valve

device which prevents passage of gas in the direction opposite to flow

[ISO 15296:2004]

3.2

manual quick-acting shut-off valve

manually activated device to quickly stop the gas flow

[ISO 15296:2004]

3.3

automatic quick-acting shut-off device

self-acting device which closes quickly, e.g. when triggered by an acetylene explosion in the high-pressure manifold pipework

[ISO 15296:2004]

3.4

remotely actuated shut-off valve

quick-acting shut-off valve which quickly stops the gas flow when remotely triggered

3.5

automatic pressure-actuated shut-off valve

device which automatically stops the gas supply to the regulator when the downstream pressure rises above the maximum operating pressure

3.6

three-way valve

device which allows gas flow from one side of the high-pressure manifold to enter the regulator while isolating flow from the second side

Note 1 to entry: Its position can be reversed so that gas flows from the second side while the first side is isolated. It prevents simultaneous flow from both sides.

3.7

stop valve

device to prevent, when closed, the flow of gas

3.8

multifunctional safety device

device which incorporates two or more of the safety functions

[ISO 15296:2004]

3.9

pressure gauge

device which shows the actual pressure of the assembly (digital or analogue readouts) (e.g. used in the high-pressure line of manifold systems or in pressure regulators for manifold systems.)

4 Design

Components within the devices should be designed to remain at the same electrostatic potential as the body of the device during operation. All metal components in contact with gas should be electrically continuous to prevent static electricity discharges.

5 Requirements

5.1 General

The general requirements (see [5.2](#)) apply to all the devices defined in [Clause 3](#). The multifunctional safety devices shall meet the general and additional requirements corresponding to each function.

5.2 General requirements

5.2.1 Materials

Materials used for devices shall be in accordance with ISO 9539.

5.2.2 External gas tightness

The general requirements on external gas tightness shall be in accordance with ISO 9090 at all times, before and after the tests.

5.2.3 Internal gas tightness

Where internal gas tightness is required in this International Standard, the leakage rate shall not exceed 50 cm³/h for devices with a connection internal bore (diameter) less than 11 mm, or less than $0,41d^2$ for larger diameters. See 6.9 for test details.

NOTE The expression $0,41d^2$ gives the value of the flow in cm³/h when d is the internal bore (diameter), in mm, of the largest connection in the device.

5.2.4 Internal gas tightness after decomposition test

Where internal gas tightness is required after acetylene decomposition, the leakage rate shall not exceed 50 l/h. See 6.9 for test details.

5.2.5 Pressure resistance

The housings of the devices shall withstand a pressure of 31,5 MPa (315 bar) for 5 min without any observed leakage. After pressurization, there shall be no visible permanent deformation. See 6.5 for test details.

5.2.6 Acetylene decomposition

After the device has been tested with decomposition at 2,5 MPa initial pressure in accordance with 6.4, there shall be no visible permanent deformation of the device. No escape of gas shall occur during the test. Destruction of inner parts is permitted.

5.3 Additional requirements to be met by specific types of device

5.3.1 Non-return valve

Non-return valves shall not allow the reverse flow of gas greater than 150 cm³/h (0,15 l/h) when tested in accordance with 6.6.1 and 6.6.2, both before and after the 2 000-cycle fatigue test (see 6.6.3).

This requirement does not apply to the non-return valve after it has been subjected to the acetylene decomposition test.

5.3.2 Manual quick-acting shut-off valve

The decomposition test shall be carried out in the open position. Manual quick-acting shut-off valves shall meet the requirements of 5.2.3 before and after the endurance test (see 6.7). In the case of turn-acting valves, they shall not require more than half of a turn to close. See 6.7 for endurance test details. For valves with handwheels, the closing torque applied for the decomposition test shall be the endurance test torque as defined in the endurance test for cylinder valves in ISO 10297.

5.3.3 Automatic quick-acting shut-off device

Automatic quick-acting shut-off devices shall be triggered by an acetylene decomposition at 0,6 MPa (6 bar) and 2,5 MPa (25 bar). After tripping by acetylene decomposition, the internal gas leakage shall meet the requirements of 5.2.4.

5.3.4 Remotely actuated shut-off valve

Remotely actuated shut-off valves shall be triggered by an acetylene decomposition at 0,6 MPa (6 bar) and 2,5 MPa (25 bar). Remotely actuated shut-off valves shall meet the requirements of 5.2.3 before the decomposition test (see 6.4) and after the endurance test. See 6.7 for endurance test details.

5.3.5 Automatic pressure-actuated shut-off valve

Automatic pressure-actuated shut-off valves shall be triggered (stop gas flow on high-pressure side) at a pressure on the low-pressure signal port between 0,16 MPa and 0,20 MPa (1,6 bar and 2,0 bar) at both 0,1 MPa and 2,5 MPa (1 bar and 25 bar) on the high-pressure side. When triggered, the internal gas leakage shall meet the requirements of [5.2.3](#). See 6.8.2.1 (test 1) and 6.8.2.2 (test 2) for details.

The valve shall not be triggered when a pressure of 0,145 MPa to 0,150 MPa (1,45 bar to 1,50 bar) is held on the low-pressure signal port for 168 h. See 6.8.2.3 (test 3) for details.

Once actuated (closed), it shall not be possible for the valve to reset to an open condition without manual intervention.

In addition to the 31,5 MPa (315 bar) pressure resistance test on high-pressure chambers in [5.2.5](#), the internal chambers of the low-pressure signal port shall withstand a pressure of 6,0 MPa (60 bar) for 5 min. During pressurization, there shall be no visible permanent deformation or leakage to the atmosphere.

Automatic pressure shut-off valves shall meet the requirements of [5.2.3](#) before the decomposition test (see [6.4](#)) and after the endurance test (see [6.7](#)). During the decomposition test, the automatic pressure shut-off valve shall not burst. No parts shall be ejected.

5.3.6 Three-way valve

Three-way valves, when closed, shall meet the requirements of [5.2.3](#) before the decomposition test (see [6.4](#)) and after the endurance test (see [6.7](#)).

During the acetylene decomposition test, the three-way valve shall prevent the decomposition passing downstream of the valve.

For valves with handwheels, the closing torque applied for the decomposition test shall be the endurance test torque as defined in the endurance test for cylinder valves in ISO 10297.

5.3.7 Stop valve

The decomposition test shall be carried out with the valve in the closed position. In this position, stop valves shall meet the requirements of [5.2.3](#) before the decomposition test (see [6.4](#)) and after the endurance test (see [6.7](#)).

During the acetylene decomposition test, the stop valve shall prevent the decomposition passing downstream of the valve.

For valves with handwheels, the closing torque applied for the decomposition test shall be the endurance test torque as defined in the endurance test for cylinder valves in ISO 10297.

6 Type tests

6.1 General

The type test methods of [Clause 6](#) shall be applied to sample devices to be tested for compliance with this International Standard. Tests shall be carried out on new devices.

6.2 Reference values and accuracy of instruments

The pressure-measuring equipment used shall be accurate to within ± 1 % of the maximum reading

All pressures shall be given in megapascals (MPa) and in bars. If the temperature at the test assembly is outside the range of 20 ± 5 °C, the pressure shall be corrected in accordance with the ideal gas law. Consequently, the test shall be carried out at low temperatures with a lower initial pressure and at high temperatures with a higher initial pressure. The minimum temperature shall be 5 °C.

6.3 Test gases

The decomposition test shall be carried out with acetylene. All other tests shall be carried out with oil-free nitrogen or air.

6.4 Acetylene decomposition test

6.4.1 General

The test shall be carried out on three samples. The device shall be installed in the test equipment so the decomposition is initiated on the upstream side.

The device described in 3.1 shall be tested in the normal direction of gas flow. Devices described in 3.2, 3.3, 3.4 and 3.5 shall be tested in the open position. Devices described in 3.6 and 3.7 shall be tested in the closed position. The shut-off valves described in 3.2, 3.3, 3.4 and 3.5 are normally in the open position and intended to work in the event of an emergency.

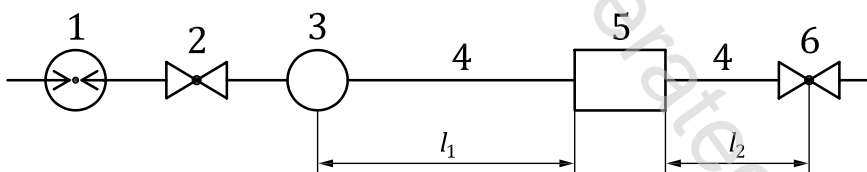
The test conditions for all types of device and the number of samples to be tested are listed in [Annex A](#).

6.4.2 Test conditions

The devices shall be checked using a test set-up as shown in [Figure 1](#) and [Figure 2](#):

- ignition tube length (l_1): 5 m;
- tube length (l_2): 1 m;
- for samples with an outlet bore up to 10 mm: the internal diameters of the tubes, d_i , shall be 10 mm;
- for samples with an outlet bore larger than 10 mm: d_i shall be equal to the nominal outlet bore;
- industrial acetylene, static gas phase;
- ignition by fusible metal wire, ignition energy less than 100 J.

When testing pressure gauges (3.9), replace element 5 in [Figure 1](#) with a special T-fitting with an internal diameter of 10 mm and a branch line (internal diameter 5 mm and length 50 mm) and connect the device to the branch line. When testing pressure gauges, the internal diameters of the tubes of length l_1 and l_2 shall be 10 mm.



Key

- 1 pressure-measuring device
- 2 inlet valve
- 3 ignition unit
- l_1, l_2 tube lengths

- 4 steel tube
- 5 test sample
- 6 outlet valve

Figure 1 — Acetylene decomposition test set-up